



(19) Europäisches Patentamt  
European Patent Office  
Office européen des brevets



(11) Publication number : 0 579 423 A1

(12)

## EUROPEAN PATENT APPLICATION

(21) Application number : 93305203.7

(51) Int. Cl.<sup>5</sup> : C09J 7/02, G09F 3/02

(22) Date of filing : 02.07.93

(30) Priority : 13.07.92 US 912851

(43) Date of publication of application :  
19.01.94 Bulletin 94/03

(84) Designated Contracting States :  
DE FR GB NL

(71) Applicant : MOORE BUSINESS FORMS, INC.  
300 Lang Boulevard  
Grand Island New York 14072-1697 (US)

(72) Inventor : Mitchell, Nancy G.  
237 South Marlin Road  
Grand Island, New York 14072 (US)

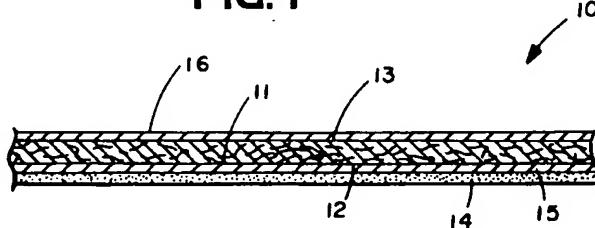
Inventor : Langan, Joseph W.  
246 Seton Road  
Cheektowaga, New York 14225 (US)  
Inventor : Russ, Timothy J.  
5654 Frontier Avenue  
Niagara Falls, New York 14304 (US)  
Inventor : Shipston, Adele C.  
153 Chestnut Hill Lane South  
Williamsville, New York 14221 (US)  
Inventor : Smith, Douglas M.  
75 Bird Avenue  
Buffalo, New York 14213 (US)

(74) Representative : Spence, Anne et al  
Fry, Heath & Spence St. Georges House 6  
Yattendon Road  
Horley Surrey RH6 7BS (GB)

### (54) Linerless labels.

(57) Linerless label stock (10) is produced from a single substrate (11) utilizing a coating machine (21) by moving the substrate through the coating machine and applying a tie coating (15) to the substrate first face (12), a release coating (16) to the substrate second face (13), and a pressure sensitive adhesive (14) to the tie coating. The tie coating comprises a dispersion of a pigment, such as silica, with a binder, such as polyvinyl alcohol. The substrate is cut to form individual labels, and is rolled up into a roll (33) with the release coated second face on the outside of the roll. Printing may be applied to the substrate prior to coating, or to the release coating.

FIG. I



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**BACKGROUND AND SUMMARY OF THE INVENTION**

Linerless labels, such as shown in U.S. patents 3,051,588, 3,285,771, and 4,851,383, and in Canadian patent 1,248,412, are known to have advantages over conventional pressure sensitive labels which are mounted on a liner which has been coated with a release coating. In the conventional labels the liner acts as a support for transport, printing and storage, and after the label is removed from the liner it must be disposed of. A linerless label, on the other hand has the face coated with a release coating, and the back with a pressure sensitive adhesive (PSA), and is wound in a roll configuration so that the PSA is in contact with the release coating, and the release coating faces outwardly. The linerless construction offers advantages and lower costs due to substantial material reduction, elimination of disposal concerns and costs associated with release coated liners, and in providing approximately twice as many labels per roll.

While linerless labels have numerous advantages, they have not had widespread commercial acceptance, perhaps due in part to impediments to easy and clean peeling off of the PSA from the release coating in the roll format. If the adhesion of the PSA to the substrate is not strong enough (and this adhesion can degrade under time under some environmental conditions and materials), adhesive may stick to the release coating, or the substrate may be torn.

According to the present invention, a linerless label stock, and a method of making linerless labels, are provided which enhance the viability of linerless labels by providing a more secure adhesion of the PSA to the substrate than is typically provided in the prior art. According to the present invention a tie coat is provided which facilitates adherence of the PSA to a first face (the "back") of the substrate, the tie coat adhering to both the substrate first face and the PSA. The tie coat preferably comprises a dispersion of a pigment, such as silica, with a binder, such as PVA. For example, the tie coat may consist essentially of about 30-40 parts silica dispersion, about 20-35 parts PVA, and about 30-40 water. Printing may be provided on the substrate first face, or may be applied onto the release coating by certain techniques.

According to the method of making linerless labels of the invention, a coating machine is utilized with a substrate having first and second faces. The method comprises the steps of: (a) Continuously moving the substrate in a first direction through the coating machine, and substantially sequentially: (b) With the coating machine, applying in a predetermined sequence to the moving substrate a tie coating to the substrate first face, a release coating to the substrate second face, and a pressure sensitive adhesive to the tie coating. (c) Cutting the substrate to form individual labels. And, (d) rolling the substrate into a roll, with the release coated second face on the outside of the roll.

In the practice of the method set forth above, the predetermined sequence of step (b) is preferably to apply the tie coating first, then the release coating, and then the pressure sensitive adhesive. The cutting step may be die cutting, and drying at a rate much faster than ambient air drying may be practiced before steps (c) and (d), by hot air, infrared, or like drying technique.

It is the primary object of the present invention to provide an advantageous linerless label stock, and a simple yet effective method for making the stock. This and other objects of the invention will become clear from an inspection of the detailed description of the invention and from the appended claims.

**40 BRIEF DESCRIPTION OF THE DRAWINGS**

FIGURE 1 is a cross-sectional view of exemplary linerless label stock according to the present invention showing each of the layers (with greatly exaggerated thickness);  
 FIGURE 2 is a side schematic view showing exemplary apparatus for practicing an exemplary method of producing linerless labels according to the present invention; and  
 FIGURES 3 and 4 are perspective views of exemplary rolls of linerless label stock of FIGURE 1, produced utilizing the apparatus in FIGURE 2.

**50 DETAILED DESCRIPTION OF THE DRAWINGS**

An exemplary section of linerless label stock is shown generally by reference numeral 10 in FIGURE 1. The stock 10 according to the invention comprises a substrate 11 having a first face 12 and a second face 13. The substrate may be any conventional substrate used in label applications, such as bond paper, latex-impregnated paper, vinyl, or polyester. The substrate is not a thermally sensitive one.

Associated with the substrate 11 is a coating of pressure sensitive adhesive 14. The PSA may comprise any conventional formulation used in pressure sensitive adhesive applications, including solvent-based, water-base, hot melt or radiation curable formulations. Typical adhesive formulations are listed in the "Handbook of Pressure-Sensitive Technology" by Donatas Satas, Van Nostrand Reinhold Company, 1983. Particularly de-

sirable PSA comprises a water-based acrylic adhesive prepared by free radical polymerization of acrylic monomers (either a homopolymer or a copolymer). For example the polymer may be made 70-100% of a soft monomer such as 2-ethylhexyl acrylate, 0-6% of functional monomer such as acrylic acid, and 0 to 30% of a hard monomer such as vinyl acetate.

5 According to the invention, adherence of the PSA 14 to the substrate 11 first face 12 is provided by a tie coating 15. The tie coating 15 adheres to both the PSA and the substrate 11. It may comprise, or consist essentially of, a dispersion of a pigment, preferably silica, with a binder material, such as polyvinyl alcohol (PVA). For example the tie coating may comprise or consist essentially of about 30-40 parts silica dispersion, about 20-35 parts PVA, and 30-40 parts water.

10 On the second face 13 of the substrate 11, which may have printing thereon (see FIGURE 3), a release coat 16 is provided. The release coating 16 is of any suitable material that imparts a lower surface energy to the face 13, and has properties with respect to the PSA 14 so that it will release easily from the PSA 14; that is the PSA 14 will not stick to the release coating 16, while it has great affinity for the tie coating 15. Typical release coatings are listed in chapters 17 and 18 of the Handbook of Pressure-Sensitive Adhesive Technology 15 by Satas, referenced above. Preferred formulations include silicone resins and chrome complexes of fatty acids.

15 FIGURE 2 illustrates exemplary apparatus for producing linerless labels according to an exemplary method of the present invention. The substrate 11 is continuously moved in the direction of arrows 18. Printing may be applied to the second face 13, as with the conventional printer 20, which may be located prior to a coating machine 21, and drives for the substrate 11 may be any conventional driving means, such as drive rollers 22.

20 In the single, conventional coating machine 21, all three of the coatings 14-16 are provided. For example a first roller or like applicator 24 applies the tie coating 15 to the first face 12, while shortly thereafter a second roller or applicator 25 applies the release coating 16 to the second face 13. A dryer 26, for effecting drying of the tie coating 15 much more quickly than by ambient air (e.g. a hot air dryer) so that the tie coat is dry by the 25 time it reaches the third roller or other applicator 27, which applies the pressure sensitive adhesive 14 over the tie coat 15, on the face 12, is also provided. The preferred location of the printer 20 is after the dryer 26 but before the second applicator 27.

25 Drying of the PSA 14 and/or the release coat 16 may be provided by dryers 29, 30 downstream of the coating machine 21 in the direction of arrows 18, and after drying by the dryers 29, 30 (which effect drying much quicker than ambient air, and may be hot air, infrared, or like conventional dryers depending upon the particular coatings); and after the stock 10 is dried, it is cut into labels by a conventional cutter 32. Then the stock is taken up in roll format 33 by take up mechanism 34, with the release coating 16 and second face 13 on the outside of the roll 33 that is being taken up, with the PSA 14 in contact with the release coating 16 in the spiral configuration of the roll 33.

30 35 Printing can also be performed (not shown) on the release coat 16 (e.g. a hot melt ink, ink jet printer).

The labels can be formed from a web which, just prior to take up 34, is slit into the rolls 33, or the rolls 33 can be formed later, after take up.

40 FIGURES 3 and 4 illustrate two different constructions of rolls of linerless label. The roll 33 of FIGURE 3 has individual labels 36 thereof which have been cut, with less than complete severing (e.g. by very fine perforations, or die cuts, indicated by cut lines 37 in FIGURE 3), generally transverse to the direction of elongation of the substrate 11 of the roll 33, with the sides 38 of each label corresponding to the sides of the substrate 11. Each label 36 has a width and length typically less than one foot. In this construction there is no waste whatsoever but rather each label 36 is merely detached along a line 37 from the next quadrate label 36 in sequence.

45 FIGURE 4 illustrates a modified form of a roll 33' of linerless labels according to the invention. In this embodiment, the cutter 32 effects complete die cutting of individual labels 36' out of the substrate, so that the edges 38' thereof do not correspond to the side edges of the substrate. The labels 36' may have any shape (they need not be quadrate), but in this embodiment there is some waste material provided by the skeletal structure 40 of the substrate outside of the labels 36'.

50 The invention having been described in general terms, one specific example of a linerless label producible according to the invention is as follows:

### Example

55 A tie coat 15 was prepared according to the following formulation:

36 parts - 20% Cab-O-Sil RSE II dispersion, Cabot Corp.

28 parts - 10% Polyvinyl Alcohol, Air Products & Chemicals (Partially Hydrolyzed)

36 parts - Water

PSA 14 was prepared according to the following formulation:

51.2 parts - 2% PVA 523, Air Products & Chemicals  
 48.7 parts - 2-ethylhexyl acrylate (monomer) BASF  
 .002 parts - Benzoyl Peroxide (BPO), Lucidol division of Pennwalt

5 A release coating 16 was prepared according to the following formulation:

15 parts - Quilon C, Valcon  
 85 parts - Water

The tie coat 5 was applied to first face 12 with the applicator 24, the release coat 16 was applied to face 13 with the applicator 25, the tie coat was dried by the dryer 26, the PSA was applied over the tie coat 15 with the applicator 27, and the entire stock 10 was dried by dryers 29, 30, and after cutting into labels 32 was self-wound in roll form 33 by winder 34.

It will thus be seen that according to the present invention linerless label stock, and a method of production thereof, have been provided which in a simple yet effective way provide easy to use labels, with no or little waste. While the invention has been herein shown and described in what is presently conceived to be the most practical and preferred embodiment, it will be apparent to those of ordinary skill in the art that many modifications may be made thereof within the scope of the invention, which scope is to be accorded the broadest interpretation of the appended claims so as to encompass all equivalent products and processes.

## 20 Claims

1. Linerless label stock (10), comprising:  
 a substrate (11) having first and second faces (12, 13);  
 a pressure sensitive adhesive (14);  
 25 a release coat (16), of material that has a low adherence to said pressure sensitive adhesive, on said second face of said substrate, characterised by  
 a tie coat (15) facilitating adherence of said pressure sensitive adhesive to said first face of said substrate, said tie coat adhering to both said substrate first face and said pressure sensitive adhesive.
- 30 2. Stock as recited in claim 1 characterised in that it is in a continuous, roll configuration (33), portions of said pressure sensitive adhesive rolled on top of portions of said release coating, with said release coating on the outside of the roll.
- 35 3. Stock as recited in claim 1 or claim 2 characterised in that said tie coating comprises a dispersion of a pigment with a binder.
4. Stock as recited in claim 3 characterised in that the pigment is silica.
5. Stock as recited in claim 3 or claim 4 characterised in that the binder is polyvinyl alcohol.
- 40 6. Stock as recited in any of claims 1 to 5 characterised in that said tie coating consists essentially of about 30-40 parts silica dispersion about 20-35 parts polyvinyl alcohol, and about 30-40 parts water.
7. Stock as recited in any of claims 1 to 6 characterised in that said substrate is cut into individual quadrilateral labels having a width and length each less than 30.5cms, the side edges (38) of the substrate forming the side edges of the labels.
- 45 8. Stock as recited in any of claims 1 to 7 consisting essentially of said substrate, adhesive, tie coat, and release coat.
9. Stock as recited in any of claims 1 to 7 characterised by printing on said substrate second face and/or said release coat.
- 50 10. A method of making linerless labels using a coating machine, and a substrate having first and second faces, comprising the steps of:  
 (a) continuously moving the substrate in a first direction through the coating machine; and substantially sequentially:  
 (b) with the coating machine, applying in a predetermined sequence to the moving substrate a tie coating to the substrate first face, a release coating to the substrate second face, and a pressure sensitiv

adhesive to the tie coating;  
(c) cutting the substrate to form individual labels; and  
(d) rolling the substrat into a roll, with the release coat d second face on the outside of the roll.

- 5     11. A method as recited in claim 10 characterised in that the predetermined sequence of step (b) is to apply the tie coating first, then the release coating, and then the pressure sensitive adhesive.
12. A method as recited in claim 10 or claim 11 characterised by the further step of printing the second face of the substrate prior to step (b) or printing the release coat.
- 10    13. A method as recited in any of claims 10 to 12 characterised in that step (c) is practiced by die cutting.

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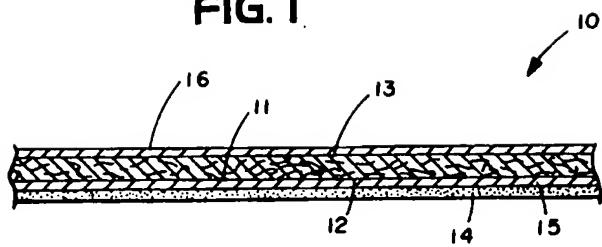
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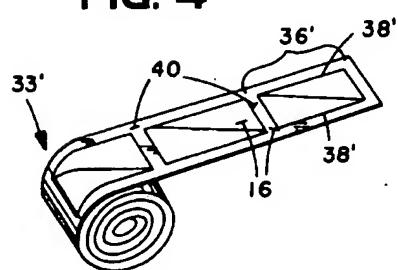
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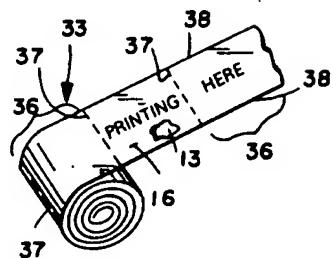
**FIG. 1**



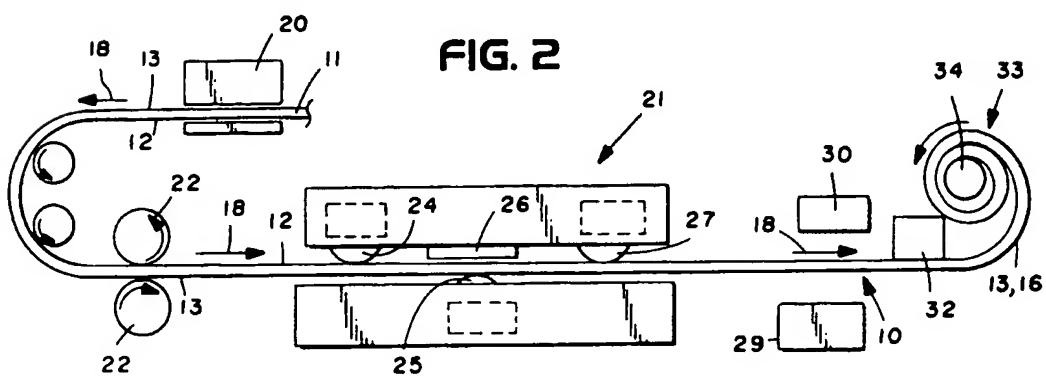
**FIG. 4**



**FIG. 3**



**FIG. 2**





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DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. CL.5)
X	EP-A-0 096 841 (MANULI AUTOADESIVI SPA) * page 4, line 11 - line 19 * * claim 1 *	1,2,8	C09J7/02 G09F3/02
X	DATABASE WPI Derwent Publications Ltd., London, GB; AN 86-121198 & JP-A-60 233 181 (NITTO ELECTRIC IND KK; NIPPON CARBIDE KOGY KK) 19 November 1985 * abstract *	1,2,8	
A	DATABASE WPI Derwent Publications Ltd., London, GB; AN 92-027503 & JP-A-3 273 079 (GOYO SHIKO KK) 4 December 1991 * abstract *	1-13	
X	FR-A-2 489 352 (MANULI AUTOADESIVI SPA) 5 March 1982 * page 2, line 6 - line 9 * * page 2, line 26 - line 29 * * page 4, line 29 - line 33 *	1,2,8,9	
A	EP-A-0 475 592 (MINNESOTA MINING AND MANUFACTURING COMPANY) 18 March 1993 * abstract *	3,4,6	C09J G09F
A	GB-A-554 019 (JOHNSON & JOHNSON) 16 June 1943 * claim 1 *	3,5,6	
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The present search report has been drawn up for all claims			
Place of search	Date of completion of the search	Examiner	
THE HAGUE	07 OCTOBER 1993	GOERKE H.R.	
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone	T : theory or principle underlying the invention		
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DOCUMENTS CONSIDERED TO BE RELEVANT			CLASSIFICATION OF THE APPLICATION (Int. Cl.5)			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim				
A	<p>US-A-4 851 383 (JOHN FICKENSCHER; WISSAM JURDI; TOMOO SHIBATA)      25 July 1989      * figure 3 *      * column 1, line 34 - line 49 *      * column 4, line 3 - line 17 *      * column 6, line 5 - line 44 *</p> <p>-----</p>	9-13				
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)			
<p>The present search report has been drawn up for all claims</p> <table border="1"> <tr> <td>Place of search THE HAGUE</td> <td>Date of completion of the search 07 OCTOBER 1993</td> <td>Examiner GOERKE H.R.</td> </tr> </table>				Place of search THE HAGUE	Date of completion of the search 07 OCTOBER 1993	Examiner GOERKE H.R.
Place of search THE HAGUE	Date of completion of the search 07 OCTOBER 1993	Examiner GOERKE H.R.				
<p><b>CATEGORY OF CITED DOCUMENTS</b></p> <p>X : particularly relevant if taken alone      Y : particularly relevant if combined with another document of the same category      A : technological background      O : non-written disclosure      P : intermediate document</p> <p>T : theory or principle underlying the invention      E : earlier patent document, but published on, or after the filing date      D : document cited in the application      L : document cited for other reasons      &amp; : member of the same patent family, corresponding document</p>						